

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013507**Date Inspected:** 23-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 7000**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Huaji**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

OUTSIDE SHOP

Segment 9DE

-This QA inspector performed in process Visual Inspection of the below mentioned fillet welds between Floor Beam and Floor Beam Flange

1. PP80(East)- FB003-149-004.
2. PP80(West)-FB003-149-005.
3. PP80(West)-FB012-022-001.

-These welds were previously MT tested and accepted by ZPMC Quality Control (QC) personnel. As per contract documents, ZPMC QC is required to perform 25% MT of these welds.

-Visually, these welds appeared to comply with the contract documents.

The member(s) are identified as OBG components – Floor Beam & Floor Beam Flange.

During visual inspection this QA inspector found that some locations in Floor beam FL2 FB003-149-005

ABF QA personnel found some linear and longitudinal indication marked on the welds 6 different location, those areas already repaired by ZPMC but grinding not yet done. These welds were previously MT tested and accepted by ZPMC Quality Control (QC) personnel. For more information please see the photos.

Segment 8AE

WELDING INSPECTION REPORT

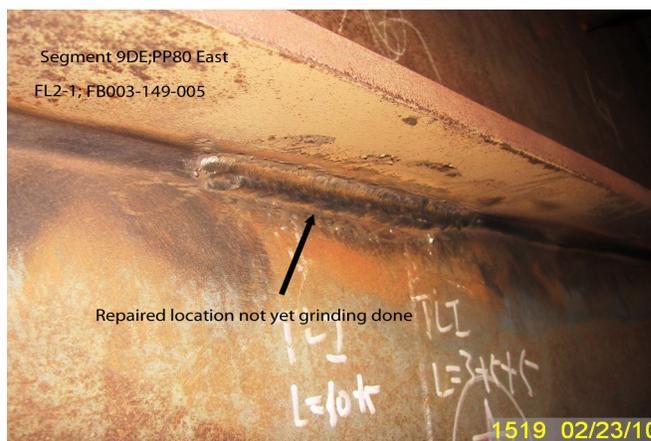
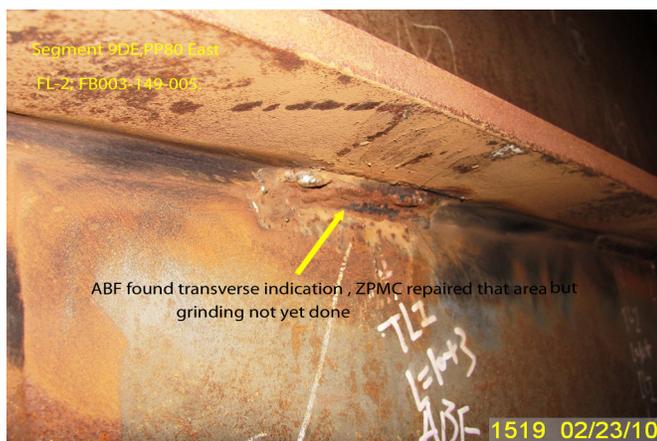
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ABF Quality control (QC) personnel performing UT scanning pattern D as per contract documents on OBG corner assembly CA48 the weld is identified as CA048-004 which is connecting Deck plate to Edge plate.

BAY#19

SMAW welding of visual repair weld joints marked by ZPMC QC personnel on PCMK SB36W,SB38W,SB40W, SB46W welder is identified as 062811,062772.ZPMC QC is identified as Mr.Zhou cheng . The welding variables recorded by QC appeared to Comply with the WPS-345-1G(1F)-Repair.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By:	Kumar,Chadra	Quality Assurance Inspector
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Reviewed By:	McClendon,Timothy	QA Reviewer
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